

Work Order ID 86724

July-06-12 11:44:06 AM

86724

M6061T6R0.750
M122081

Page 1

Item ID: D2057

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plug

Start Date: 7/06/12

Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-9

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2057	Rev C

100	Hardinge CNC LATHE SMALL	0.00							
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100

Hardinge

Hardinge CNC Lathe Small

Memo

Make as per Dwg D2057 and Folio FA260.

Break all sharp edges 0.015 max.
Do not drill Ø0.191

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110

QC

Quality Control

Memo

120	QC8- Inspect parts - second check	0.00							
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120

QC

Quality Control

Memo

DAS
14 12/10/15
9-89

13

13

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86724***86724***

Page 2

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Item ID: D2057

Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Plug

Start Date: 7/06/12

Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **ST 4**

0.00

130

Packaging

Memo

0.00

Packaging

13x**SP****12-10-16.**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/10/18**MF****12-10-17**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

July-06-12 11:44:06 AM

Page 1

Work Order ID: 86724

Parent Item: D2057

Parent Item Name: Plug

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP D02.08.22Make in CobraKJ
 IPP Rev:E 08-05-27 as per ECN1195P DD verified by:EC
 IPP Rev:F 08-06-04 Added QC8 JLM Verified By:EC
 IPP Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	72.0630	0.1	1.2631584			

Location	Loc Qty	Loc Code
MAT012	6.5	
120734	6.5	
MAT013	65.563	
121282	5.563	
122081	60	

SA 12/10/12

1.3 Rt

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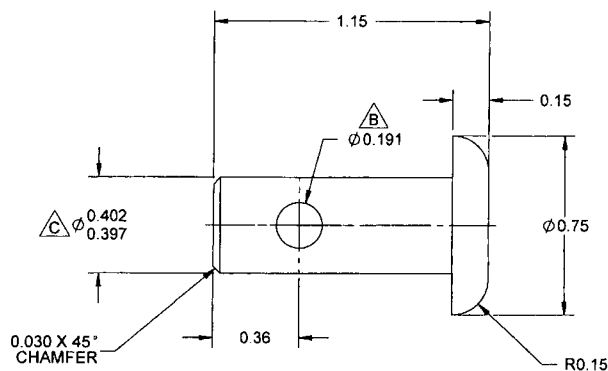
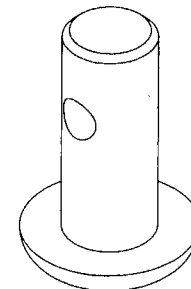
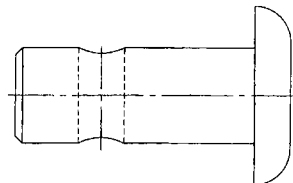
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D2057 PLUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86724

RD 07-9

RELEASED
08.06.10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

C	Ø0.402/Ø0.397 WAS Ø0.430/Ø0.425; REASON: ID OF D2010-1031-104 DECREASED TO Ø0.402	PH	08.06.10
B	REDRAWN: Ø0.191 WAS Ø0.187 (TSR A1100)	CP	98.10.15
A	NEW ISSUE	JB	92.03.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2057	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLUG	NTS
DATE	08.06.10	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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